



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D205-634-141
Job Sheet 170009



Part No: D205-634-141

Job Qty: 1 ea

Part Name: Replacement Skidtube with Run-on Landing Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/5/18

Job Tracking No:

Due Date: 1/31/18

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Kestrel Aviation Pty Ltd (CKEST03)

325 Aerodrome Road Mangalore, Victoria, 3663 Australia

Note: DWG REV I IPP RevA 11.09.14 new issue EC verified by:DD IPP REV:B 12.01.23 AS PER ECN11-684 DD
VERF:EC IPP REV:C 13.03.21 AS PER ECN13-544 DD VERF:JLM

Ship Via: D2580 REV H DA

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/30/18	0.00	0.00	Start Up Skidtubes-1		
110	Skidtubes	1 pcs		1/30/18	0.00	0.65	Skidtubes-2		<u>MGB</u>
120	CNC Bend Skidtubes	1 pcs		1/30/18	0.52	0.65	CNC Bend Skidtube		<u>MGB</u>
130	Skidtubes	1 pcs		1/30/18	0.00	0.65	Skidtubes-2		<u>MGB</u>
140	QC	1 pcs		1/30/18	0.00	0.00	QC5		<u>BE</u>
150	Skidtubes	1 pcs		1/30/18	0.00	0.65	Skidtubes-2		<u>THASBE</u>
160	QC	1 pcs		1/30/18	0.00	0.00	QC10		<u>38 DAS</u>
170	QC	1 pcs		1/30/18	0.00	0.00	QC5		<u>9-88 38</u>
180	HandFinish	1 pcs		1/30/18	0.00	0.04	HandFinish2		<u>18-02-89 81</u>
190	Powdercoat	1 pcs		1/30/18	0.00	0.25	Powdercoat1		<u>18-2-12</u>
200	QC	1 pcs		1/30/18	0.00	0.00	QC3		<u>BE 18-02-12</u>
210	HandFinish	1 pcs		1/31/18	0.00	0.83	HandFinish4		<u>BE 18-02-13</u>
220	QC	1 pcs		1/31/18	0.00	0.00	QC5		
225	DC	1 pcs		1/31/18	0.00	0.00	DC		
230	Packaging	1 pcs		1/31/18	0.00	0.00	Packaging3-1		
240	QC21-FG	1 Ea		1/31/18	0.00	0.00	QC21		<u>DAS</u> <u>2 FEB 1 1 2018</u>

Part Op 110 - 1- PICK D2580-1 2- SPOT DRILL 2 AFT RUN ON WEARPLATE HOLES USING DT10021, DRILL 3.630" HOLES
Descriptions: USING DT8462 (83.94" FROM AFT OF D2580-1 REF. ONLY)

120 - 1-Bend as per program D2580.C on CNC Bender and Folio FT 16

130 - 1-Deburr ends after cutting and remove bending marks. Prepare tube for welding D2576-3 step remove alodine as required. 2-Locating from most fwd saddle hole, drill most fwd wearplate hole using DT9793 (10.832 REF) as per dwg D2580 sheet 7. 3-Open run-on wearplate holes to finished size 0.508" at locations (5.338/ 5.985/ 10.832/ 3.63 REF) as per dwg D2580 sheet 7. 4-Drill pilot holes for aft cap using DT8215, Open to finished size.

150 - 1-Weld step D2576 as per Dwg. D2580 and QSI 004 A/R Aluminum Rod M138672 2-Touch up alodine on run on wearplate holes prior to swaging 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and as per dwg 4-DRILL TOWING HOLE USING DT8091 5-DEBURR

180 - And realodine tube as per QSI 005

190 - START TIME: 9:15 AM To 4:40 PM 31st M138487

18/04 210 - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 M138654 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594 3- Install aft cap as per dwg 4- Wing walk as per dwg Batch# M138711

220 - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

DQA:

Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

Work Order update only

Work Order: _____

Part No. _____

NCR No. _____

Date: _____

Step #: _____

Description Work Order Deviation

DISPOSITION

☐ Rework
☐ Scrap
☐ Use-as-is
☐ Suspected Unapproved

Skid-tube
 Mac
 Thermoco
 Latex
 QTY

AGAINST DEPARTMENT/PROCESS

☐ Engineering
☐ Quality
☐ Other

42) Approval

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Supervisor
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Dart Aerospace Ltd.

1270 Aberdeen Street
 Hawkesbury, ON K64 1K7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Turning Sequence

DART
 AEROSPACE
S040271



Replacement Skidtube with Run - on Landing Wearplates Fits
 LH or RH

PART NO: D205 - 634 - 141

Original Serial #: S040271

Revision:

Operation:

Change No:

Start up Operation 02/07/18
CHG004

Job No: 170009

Root Cause

Environment	No Re-verification
Design	Operator
Doc/Data	Offset/Setup
Equip/Tooling	Supplier
Handling/Pre	Training
Material	Use for Testing
Internal Transport	Poor Information
Tribal Knowledge	Rushing
LOA	Product Improvement
Substation	Process Improvement
Past Expiry Date	Manufacturing Process
Misidentified	Past Due

Pressure/Forced	Temperature/Cu
Bending	Set-up
Centre Not Concentric	BOM/Route
Cracks	Broken/Damage,
Crimp/Kink/Ripple/Wave	Inspection Incom
Cuffs	Contamination
Crushing	Countersink
Heat Treat	Cut Too Short
Wave/Twist in Tube	Instructions Incon
Marks/Chatter	Drill Holes

OTHER :

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2580-1 <i>5036987</i>	1	7	0	0
150-Skidtubes	D2576-3 <i>8156023</i>	1	56	0	0
	D4202-1 <i>5030798</i>	24	716	0	0
210-HandFinish	AN3-5A <i>5013737-1</i>	2	454	0	0
	AN4-45A <i>5038734</i>	8	76	0	0
	D2570 <i>5030004</i>	16	132	0	0
	D2594-1 <i>5025442</i>	8	492	0	0
	D2594-3 <i>5055836</i>	8	145	0	0
	D2855 <i>F151613</i>	1	78	0	0
	D4406-041 <i>5041000</i>	1	2	0	0
	D4406-043 <i>5041314</i>	1	0	0	0
	MS21042-4 <i>5038763</i>	8	3	0	0
	NAS1149D0332J <i>5020606</i>	2	616	0	0

Part Specifications

Specifications could not be found.

Plex 1/5/18 3:17 PM dart.poulin.mario

000813

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

ITEM	QTY -041	QTY -045	QTY -047	QTY -048	PART NUMBER	DESCRIPTION
1	X				D2580-041	SKIDTUBE ASSEMBLY
2		X			D2580-045	SKIDTUBE ASSEMBLY
3			X		D2580-047	SKIDTUBE ASSEMBLY
4				X	D2580-048	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2500-1-190	EXTRUSION
21			16	16	D2570	BUSHING
22	1	1	1	1	D2575-3	STEP
23		4			D2579	SPACER
24	16	16	8	8	D2594-1	PLUG
25	16	16	8	8	D2594-3	O-RING
26	1	1	1	1	D2598	205 WEB
27	1	1	1	1	D2855	AFT CAP
28	1	1			D3584-5	WEARSHOE
29	1	1			D3584-9	WEARSHOE
30	1	1			D3584-11	WEARSHOE
31	1	1			D3584-13	WEARSHOE
32	20	20	24	24	D4202-1	SPACER
33			1		D4406-041	WEARPLATE ASSEMBLY
34			1		D4406-043	WEARPLATE ASSEMBLY
35				1	D6061-1	FWD WEARPLATE
36				1	D6061-3	AFT WEARPLATE
60	50	50			ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
61	50	50			AN3C4A	BOLT
62	2	2	2	2	AN3-5A	BOLT
63			8	8	AN4-45A	BOLT
64	50	50			NAS1149C0332R	WASHER (AN980C10L)
65	2	2	2	2	NAS1149D0332J	WASHER (AN980JD10L)
66			8	8	MS21042-4	NUT (OR MS21042L4)

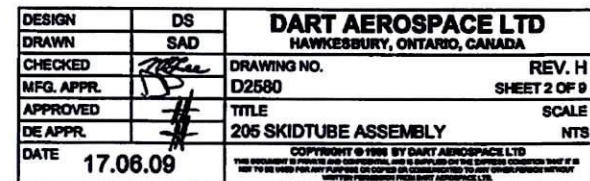
GENERAL NOTES:

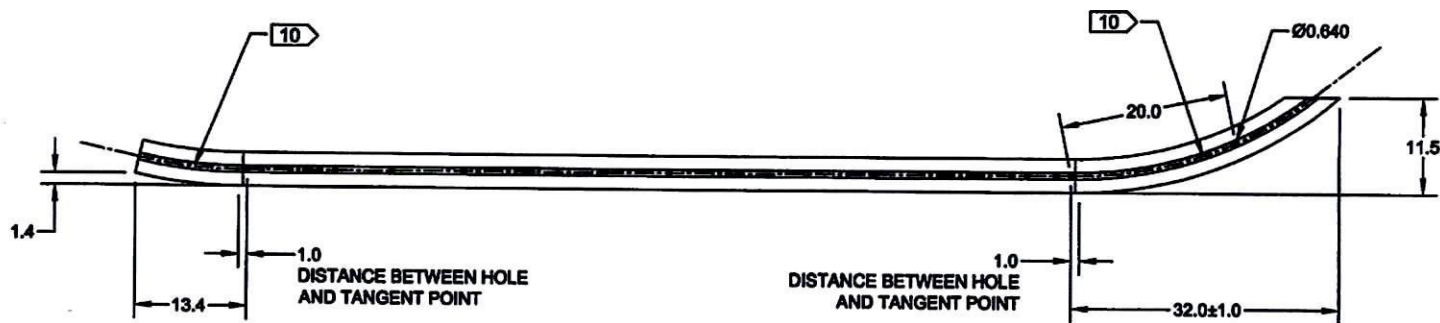
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2598 WEB
POWDER COAT (-041/-047/-048) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
POWDER COAT (-045) GREEN SANDTEX (REF 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 33.7 lbs
D2580-045 = 33.7 lbs
D2580-047 = 45.1 lbs
D2580-048 = 32.0 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2598 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8217 & DT8837 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (8 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/-281.
- 12) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED "P" (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047/-048)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

H	SHEET: PL DELETE D3586-1/-5/-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.09
G	ADDED -048, -047 WEIGHT UPDATED PER DSI 9598	AJS	14.04.09
F	INCORPORATE DEO D2580-E-1 PER PAR12-218	DC	13.06.20
E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-5); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8837 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 8124/8183	PH	07.04.06
C	REDRAWN, INCLUDED DEO 9084/ 9087	CP	96.08.26
B	AS MANUFACTURED	DS	96.12.02
A	NEW ISSUE	DS	96.08.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 1 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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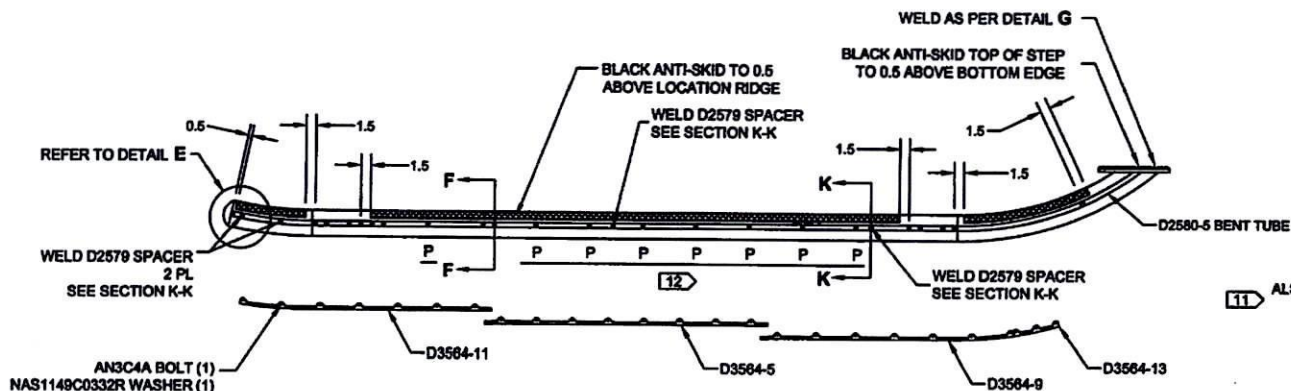




D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

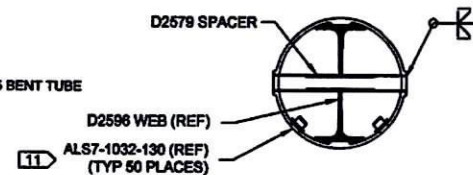
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MPG. APPR.	<i>[Signature]</i>	D2580	SHEET 3 OF 9
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D2580-045 ASSEMBLY DETAIL

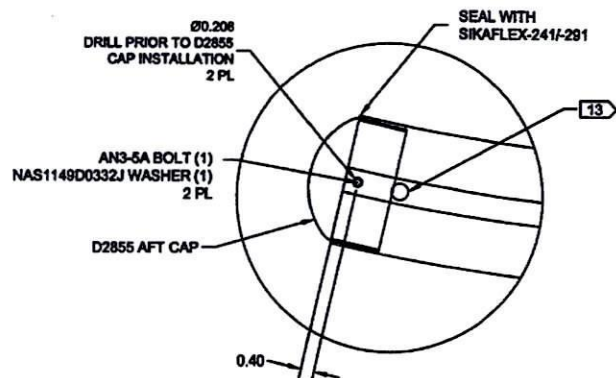
SECTION K-K
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

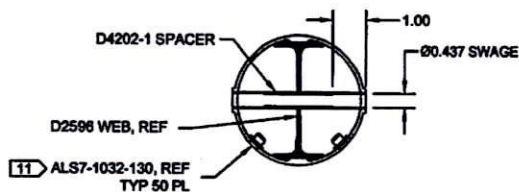
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (4 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. DO NOT C'BORE

DETAIL E
SCALE 5X



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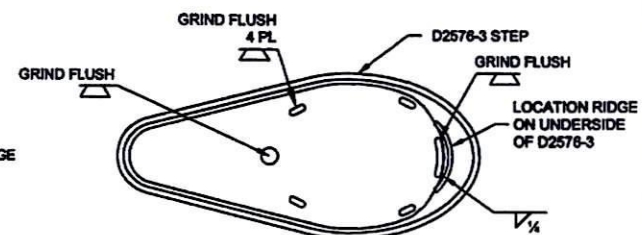
SECTION F-F
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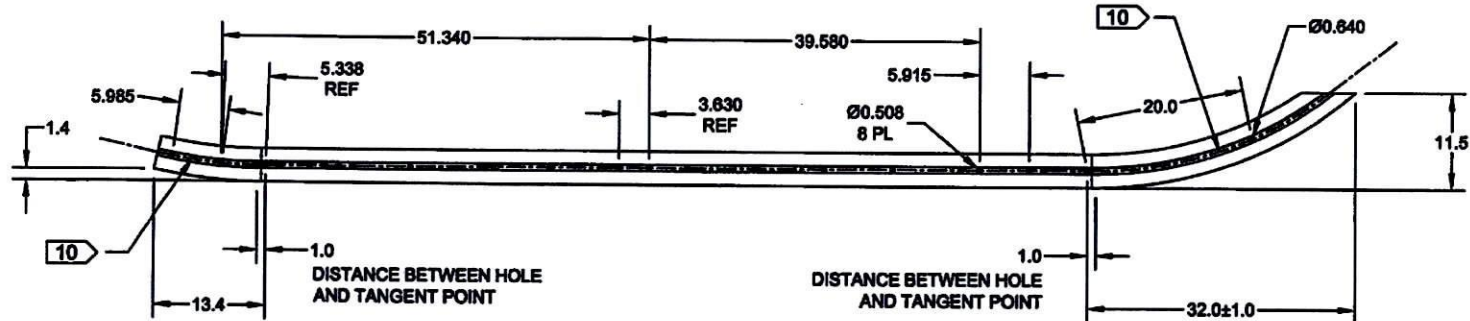
AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

DETAIL G
SCALE 5X



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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 4 OF 9
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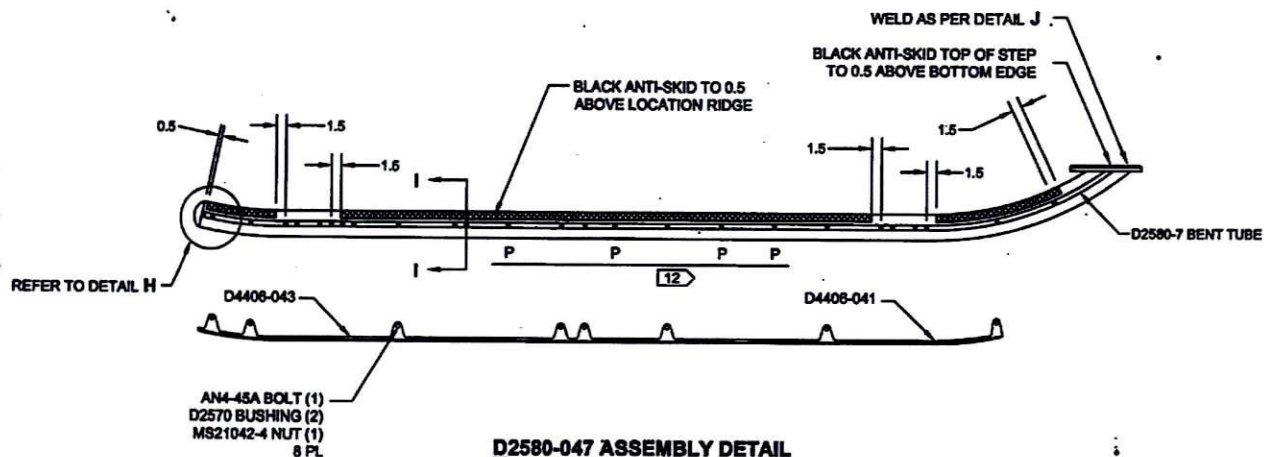


D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

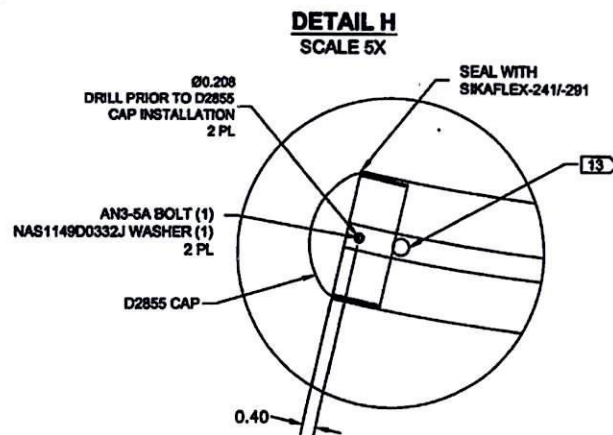
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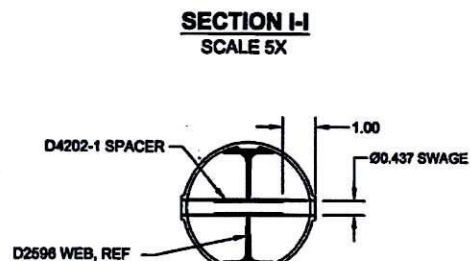
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MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 6 OF 8
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D2580-047 ASSEMBLY DETAIL

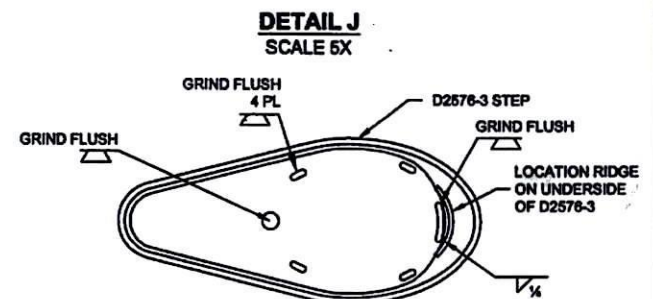


**DETAIL H
SCALE 5X**



**SECTION I-I
SCALE 5X**

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

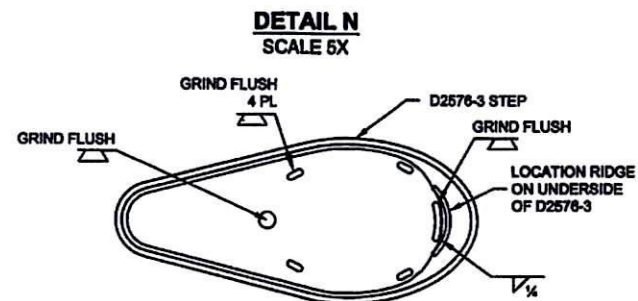
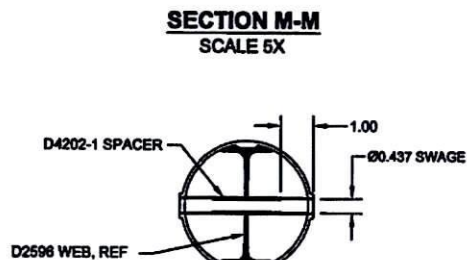
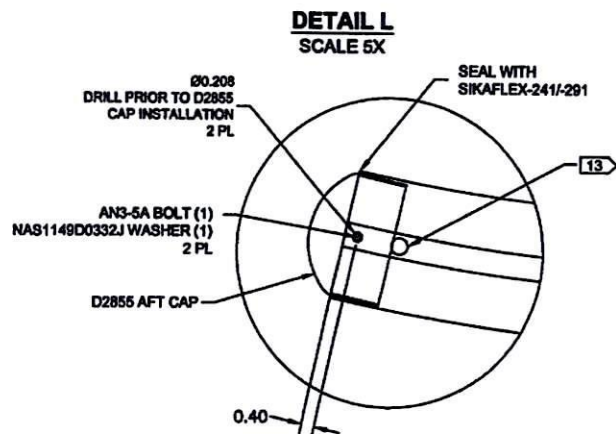
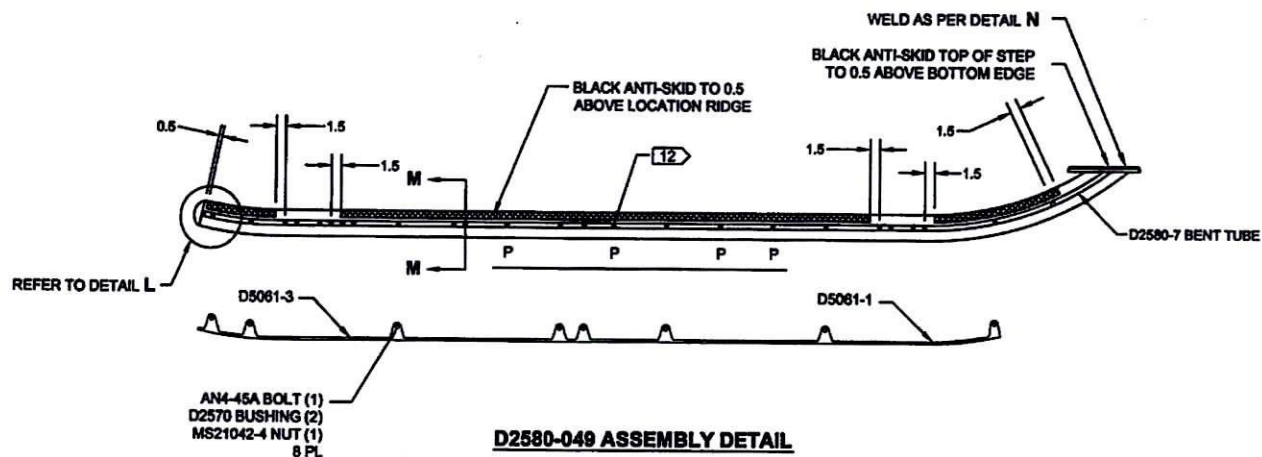


**DETAIL J
SCALE 5X**

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 8 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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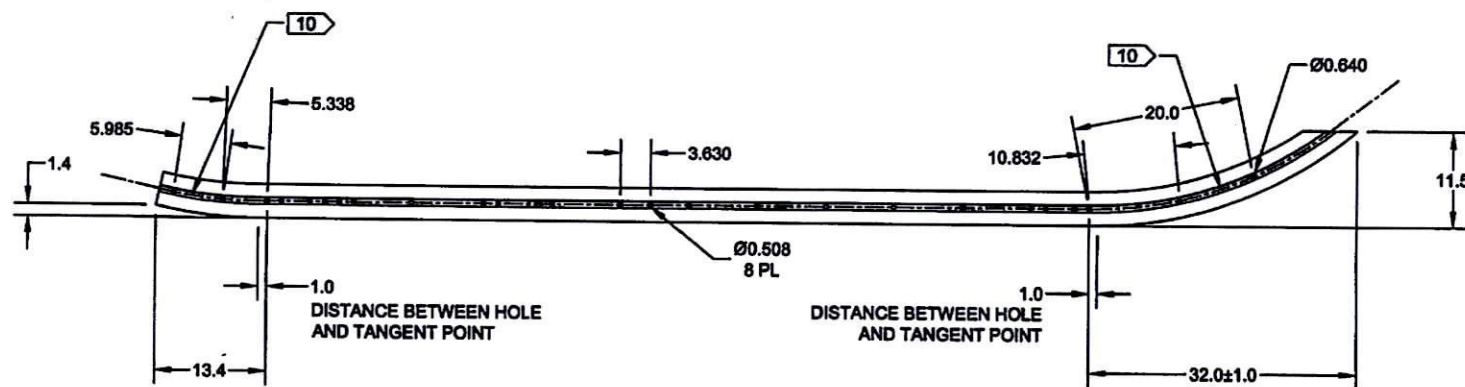


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3. TRIM/GRIND FLUSH PER QSI 002

RELEASED

2017 JUL 05

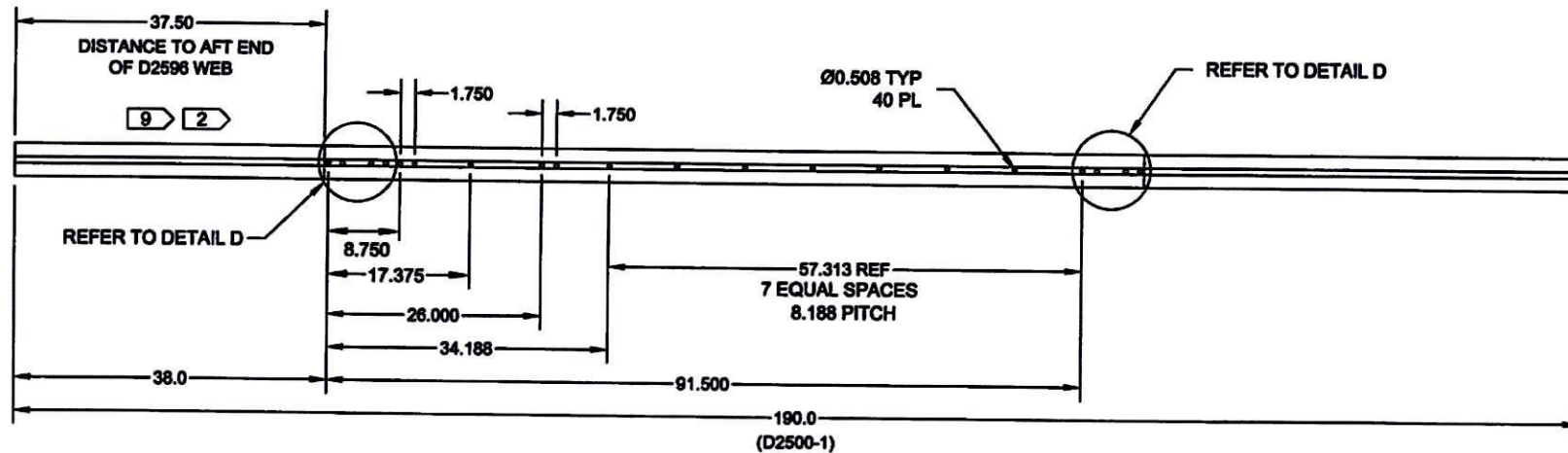
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 7 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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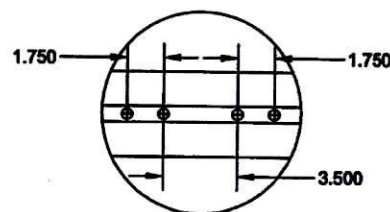
D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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D2580-101 TUBE



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